

Work Order ID 75061

October-17-11 10:44:43 AM

75061

Page 1

Item ID: D3296-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Door Panel

Stop

NS2

Start Date: 17/10/2011 Start Qty: 12.00

12

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/10/11

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3296	Rev A								
100		0.00							
100	FLOW WATER JET								
Waterjet									
FLOW CNC Waterjet									
2024 .063									
	Memo	0.00							
	1-Cut as per Dwg D3296	Dwg Rev: <u>A</u>	Prog Rev: <u>A</u>	2-					
	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC									
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC									
Quality Control									

W 11-11-03 (16)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Memo
Deburr

N/A

0.00

140

140

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

Memo

0.00

K. BR 11-11-3.

150

150

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

16X JML 11/11/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

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12

Cust Item ID:

Required Date: 28/10/2011 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--	----------------------------------	------------------------------	----------------	---------------	----------------------	-----------------------	-----------------------	--------------------------	------------------------

160

Packaging

Packaging

Identify as per dwg & Stock Location: St 186

0.00

SP 11-11-04

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/11/04

11/11/04
(14)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:44:49 AM

Page 1

Work Order ID: 75061

75061
D3296-3

Parent Item: D3296-3

Parent Item Name: Door Panel

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:E Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	94.5000	0.6532	8.250947	10.5	17/10/2011	

M2024T3S 063

2024-T3 .063 sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	94.5	
117392	94.5	117392

(16)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

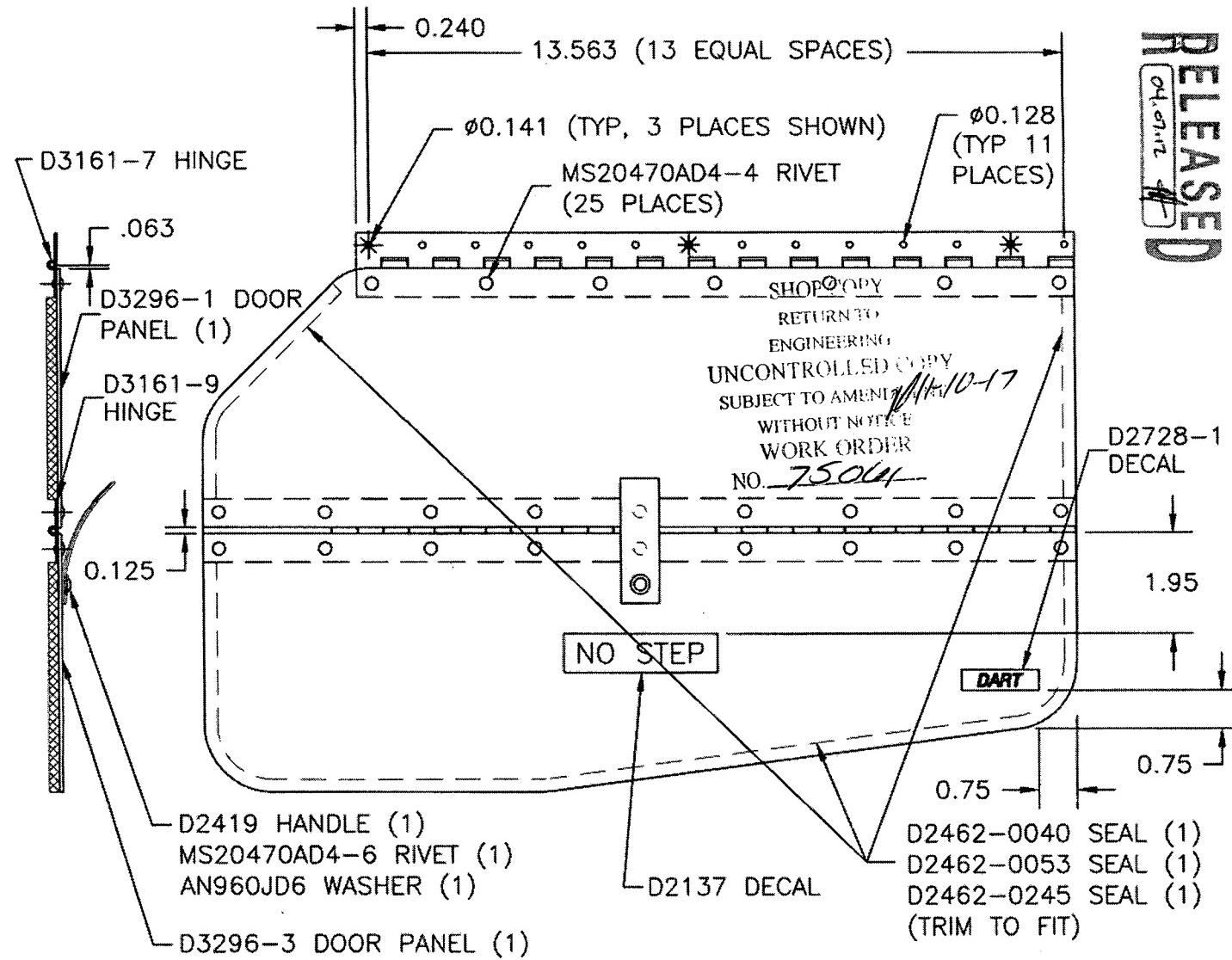
DART AEROSPACE LTD	Work Order:	75001
Description: Door Panel	Part Number:	D3296-3
Inspection Dwg: D3296	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	MJW	Prototype Approval:	N/A
Date:	11-11-03	Date:	11-11-03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	P/O D3296-041	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.06.28

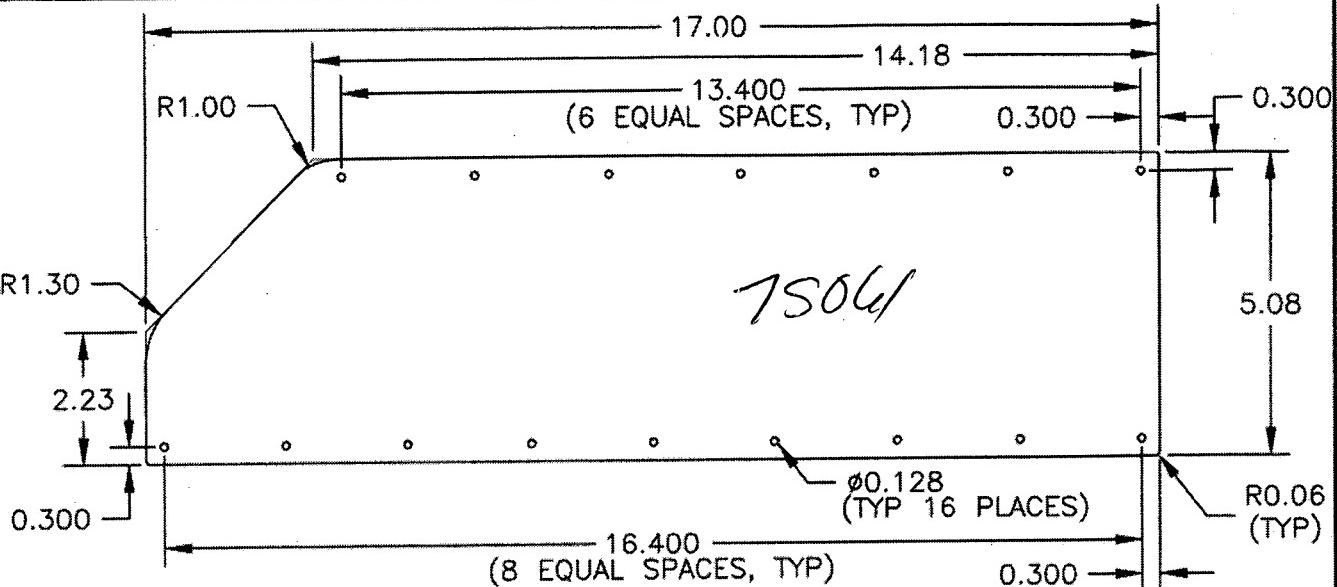
DART

ACROSS
OCTOBER
2004

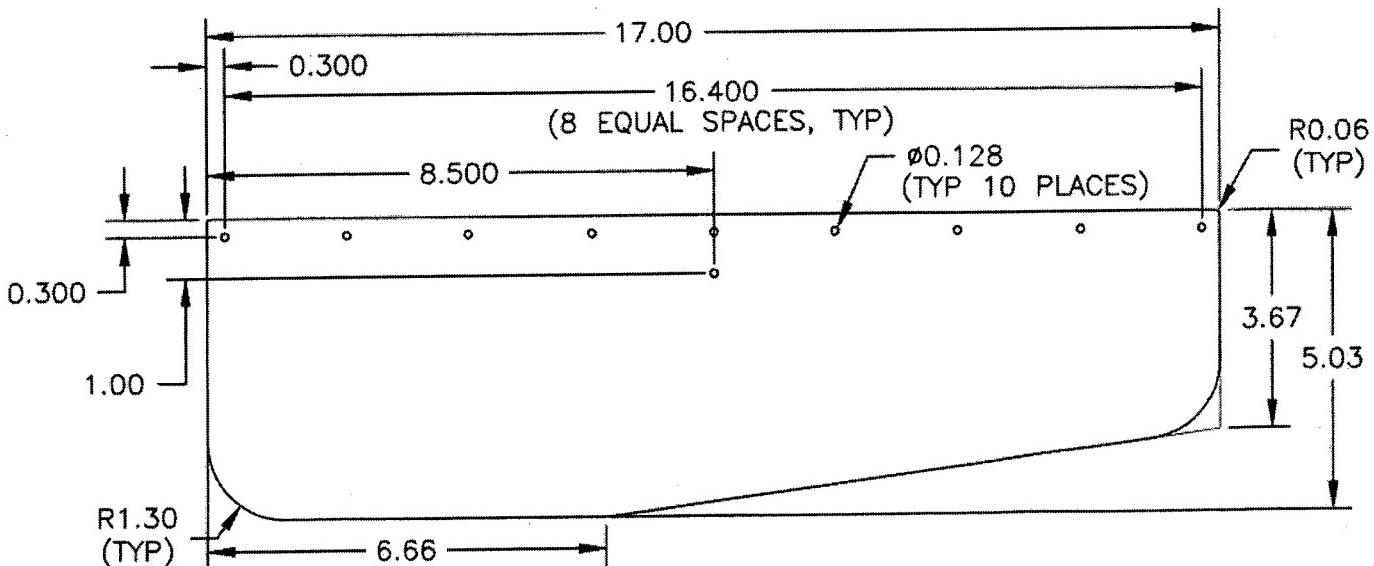
DESIGN	DRAWN BY	DART AEROSPACE LTD
IP	JP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3296
DATE	TITLE	REV. A
04.06.28	DOOR ASSEMBLY	1 OF 2
A	04.06.28	SCALE
	NEW ISSUE	1:3



DESIGN CP	DRAWN BY AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28	TITLE DOOR ASSEMBLY	SCALE 1:3	



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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